Work Order ID 97645 Page 1 Thursday, February 21, 2013 10:23:39 AM Item ID: D4030-041 Accept \*N900040100\* **Revision ID:** Item Name: Long Basket Assembly (350) Start Qty: 1.00 **Start Date:** 2/21/2013 **Cust Item ID:** Req'd Qty: 1.00 Required Date: 2/28/2013 **Customer:** Reference: Run **Tooling:** Approvals: **Process Plan:** Date: Stop Date: QC: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Reject Accept Insp. **Work Center ID** Code Qty Qty Number Stamp Description **Run Hours** Draw Nbr **Revision Nbr** D4030 C 100 Pick Kit 0.00 \*100\* Packaging 0.00 Memo Packaging 0.00 110 Assemble as per dwg \*110\* HandFinish<sup>\*</sup> 0.00 \*\*\*\*Mask label plate to size of D4086 label, use scotchbrite red pad to lightly Hand Finishing sand area for label, apply label \*\*\*\* QC5- Inspect part completeness to step on W/O 120 \*120\* QC Memo

Quality Control

										DQA:	Date	:
NCR: Y	es / No				WORK ORDER NON	-COI	NFORM	MANCE / UP	DATE	QA Closed:	Date	::
Work Orde	r·				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part N	0				Rework Scrap Use-as-is Work Order Update		Skid-tube Crosstube Machining Small Fal Thermoforming Finishin Large Fab Composite			Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier		Engineering Quality Other
Root	_				iption of work order update	1	nitial		tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data												
equip/Tooling	_											
Operator	_											
Material		İ										
Setup Other	$\dashv$	ļ				i						
Process												
Supplier												
Training	7											:
Unapproved		İ				-						
		1	·	I		FAUL	T CATE	GORY				
Landir	ng Gear		,		General					_		
	Bending				Bend		Grain			Ovalized		Pressure/Forced
	Centre No	ot Conce	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
[	Cracks				Broken/Damaged		Inspect	on Incomplete		Part Incorre	ct	Weld
ļ	Crushed/	Crimped.	-		Burrs		Instruct	ions Incomplete/	'Unclear	Part Lost/M		Wrong Stock Pulled
	Cuffs				Contamination		Mainte	nance		Part Moved		
ļ	Heat Treat Countersink			<u>_</u>	Mislabe		ļ	Positioned \		_		
	Inspectio	•	Tube		Cut Too Short	_	Misread	d		Power Loss/	'Surge	Other
	Ripples in	Bend			Drill Holes		Offset					
	Torque W	Vaves in E	Extrusio	n  _	Drawing		4	Calibration				
	Turning S	equence			Finish		Out of	Sequence				

Outside Dimensions

Wave/Twist in Tube

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID 97645 \*97645\* Thursday, February 21, 2013 10:23:39 AM Item ID: D4030-041 Accept Setup Start \*N900040100\* **Revision ID:** Long Basket Assembly (350) Item Name: **Start Date:** 2/21/2013 Start Qty: 1.00 Cust Item ID: **Req'd Qty:** 1.00 Required Date: 2/28/2013 **Customer:** Reference: Run Start Process Plan: Date: **Tooling: Approvals:** Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Reject Accept Number Stamp **Work Center ID Description** Code Qty Qty **Run Hours** 130 Identify as per dwg & Stock Location:\_\_\_\_\_ 0.00 \*130\* 0.00 Packaging Memo Packaging

140

QC21- Final Inspection - Work Order Release

0.00

\*140\*

Quality Control

Memo

0.00

Insp.

Page 2

D13-03-14

											DQA:	Date	e:	
NCR: Y	es / No					WORK ORDER NON-C	100	NFORI	MANCE / UP	DATE	QA Closed:	Date	ō: 	,
Work Orde	r·					DISPOSITION		AGAINST DEPARTMENT/PROCESS						
Part N NCR N	0					Rework Scrap Use-as-is Work Order Update		Skid-tube Crosstul Machining Small F Thermoforming Finishi Large Fab Composi			Prod. Eng. Coor. Qua		Engineering Quality Other	
Root Cause					-	tion of work order update  Non-conformance	1	nitial ief Eng		tion ription	Sign & Date	Verification		QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved				.Â										
	*					F.	AUL	T CATE	GORY					
Landin	g Gear					General		•			7	_		
	Bending Centre Not Concentric to O/S Cracks Crushed/Crimped. Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion					Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing		Grain Hardware Inspection Incomplete Instructions Incomplete/Unclear Maintenance Mislabeled Misread Offset Out of Calibration			Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned V	ct issing Wrong	V V	Pressure/Forced Femperature/Cure Weld Wrong Stock Pulled Other
	Turning Sequence Finish						Out of	Sequence						

Outside Dimensions

Wave/Twist in Tube

## **Picklist Print**

Thursday, February 21, 2013 10:23:43 AM

Work Order ID: 97645

\*97645\*

Parent Item:

D4030-041

\*D4030-041\*

Parent Item Name: Long Basket Assembly (350)

**Start Date: 2/21/2013** 

Required Date: 2/28/2013

Page 1

Start Qty: 1.00

5.0000

Required Qty: 1.00

Comments:

IPP Rev:A new issue DD 10.03.23 verified by:EC

per dwg revB DD 10.04.20 verified by:EC

IPP Rev:B as IPP Rev:C as per dwg

Manufactured

Manufactured

IPP Rev D 12.03.27 per NCR12-

revC DD 10.08.18 verified by:EC 1239 EC verified by:ILM

	1239 EC verified	by:JLM											
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4086-200		Manufactured	No				Each	15.0000		1	_		
*D4086-20 Placard, Max Load	<b>N</b> 0*								**				
				Location		Loc (	<u>)tv</u>	Loc Code					
				ST093			15				_		
					88611		5		-	<u>.</u>	<del>-</del> ·		
					96251		10			16201	<u>/</u>		

*[	72	25	3	O	*
	11 . 31	. 11			

Handle Weldment

<b>Location</b>	<u>Lo</u>	e Oty	Loc Code		
ST255		5			
94474		5			
	100	Each	110.0000		
				**	

100

*	n	2	5	3	5	*
ο.						

Spring

D2535

D2530

<u>Location</u>	Loc Qty	Loc Code	
ST011	110		
86333	. 10		80
92570	50		
96248	50		

Each

NCR: Y	es / No				WORK ORDER NON-O	100	NFORM	MANCE / UPDAT	ΓE			
								-		QA Closed:	Date	:
Work Orde	r:				DISPOSITION			,	AGAINST DEF	PARTMENT	/PROCESS	
Part No					Rework Skid-tube Crosstube  Scrap Machining Small Fab  Use-as-is Thermoforming Finishing  Work Order Update Large Fab Composite			Small Fab Finishing	Pro Rec/Stor	Engineering Quality Other		
Root				Descri	ption of work order update	I	nitial	Action		Sign &		
Cause	Date	Step	Qty		or Non-conformance	Ch	ief Eng	Description	on	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved												
						AUL	T CATE	GORY				<u> </u>
Bending Centre Not Concentric to O/S Cracks				General Bend BOM/Route Broken/Damaged		Grain Hardware Inspection Incomplete			Ovalized Over/Under Part Incorre	ct	Pressure/Forced Temperature/Cure Weld	
Crushed/Crimped Cuffs				Burrs Contamination	-	Instructions Incomplete/Unclear  Maintenance			Part Lost/M Part Moved	issing	Wrong Stock Pulled	

Mislabeled

Out of Calibration

Out of Sequence

Outside Dimensions

Misread

Offset

DQA:

Positioned Wrong

Power Loss/Surge

Other

Date:

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Thursday, February 21, 2013 10:23:43 AM

Work Order ID: 97645

\*97645\*

Parent Item:

D4030-041

\*D4030-041\*

87524

92711

94713

Parent Item Name: Long Basket Assembly (350)

Start Date: 2/21/2013

Required Date: 2/28/2013

\*\*

Start Qty: 1.00

Required Qty: 1.00

D2537

Bushing

Manufactured No 100

Each

98.0000

Location Loc Code Loc Qty ST011 98

D3913-041

D3914-041

Manufactured No

Manufactured

Manufactured

No

100

40 Each

Each

90.0000

34

24

Each

\*\*

\*\*

\*\*

\*D3917-3\*

Long Basket Base Assemby, 350

Long Basket Lid Assembly (350)

Washer

D3917-3

Location	Loc Qty	Loc Code
ST072	90	
92514	29	
94136	5	
94137	6	
94643	50	

100

												DQA:	Da	ite:	
NCR:	Yes	/ No				WORK ORDER NON-C	100	<b>NFORM</b>	MANCE / UP	DATE					
									-			QA Closed:	Da	ite:	
Work Ord	or.					DISPOSITION				AGAINST I	DΕ	PARTMENT	PROCESS		
WOIK OIG	CI.			<del></del>	<del></del>	Rework Skid			Skid-tube	Crosstube		]	Water Jet		Engineering
Part I	۷o.					l    {			Small Fab	Prod. Eng. Coor.			Quality		
,						Use-as-is			noforming	Finishing			e/Packaging	-	Other
NCR I	Vo.					Work Order Update	1 1	•	Large Fab	Composite		1	Supplier	$\vdash$	
	•						•								
Root					Descri	ption of work order update	1	Initial	Ac	tion		Sign &			
Cause		Date	Step	Qty	(	or Non-conformance	Ch	nief Eng	Desc	cription		Date	Verificatio	'n	QC Inspector
Doc/Data															
Equip/Tooling	Ш			-											
Operator														1	
Material															
Setup						•									
Other														l	
Process				•											
Supplier	Ш					·									
Training															
Unapproved							<u> </u>								
						F/	AUL	T CATE	GORY						
Landi	ng (	Gear				General	_	,		r		,		_	T
	Bending					Bend		Grain				Ovalized			Pressure/Forced
	Centre Not Concentric to O/S			o/s ´	BOM/Route	<u></u>	Hardwa	re	ļ		Over/Under	tolerance		Temperature/Cure	
	Cracks			Broken/Damaged	<u></u>	Inspecti	on Incomplete			Part Incorre	ct		Weld		
	Crushed/Crimped.			Burrs		Instruct	ions Incomplete	/Unclear		Part Lost/Missing		Wrong Stock Pulled			
1	Cuffs Contamination					Maintenance				Part Moved					

Mislabeled

Out of Calibration

Out of Sequence

Outside Dimensions

Misread

Offset

Positioned Wrong

Power Loss/Surge

Other

Turning Sequence
Wave/Twist in Tube

Ripples in Bend

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

Countersink

Cut Too Short

Drill Holes

Drawing Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Thursday, February 21, 2013 10:23:43 AM

Work Order ID: 97645

\*97645\*

Parent Item:

D4030-041

\*D4030-041\*

Parent Item Name: Long Basket Assembly (350)

**Start Date: 2/21/2013** 

Required Date: 2/28/2013

\*\*

Start Qty: 1.00

Required Qty: 1.00

D3953-3

Manufactured

No

100

Each 45.0000

2

Gas Spring Stud, Lid

Location	<u>1</u>	Loc Oty	Loc Code
GA		1	
	87592	1	
ST076		44	
	88494	14	

100

Manufactured No 94744

30 Each 57.0000

\*\*

Spring Spacer

D3953-7

Location	<u>Lo</u>	e Oty	Loc Code
ST076		57	
88393		5	
89248		12	
94669		40	
	100	Each	95.0000

D3953-9

Manufactured No

\*\*

\*D3953-9\* Gas Spring Washer

> Location Loc Qty Loc Code ST076 95 94719 50 95127 45

									DQA:	Date: _	
NCR: Y	es / No				WORK ORDER NON-C	ONFORM	MANCE / UP		QA Closed:	Date:	
Work Orde	r.				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part N					Rework Scrap	'	Skid-tube Machining	Crosstube Small Fab		Water Jet d. Eng. Coor.	Engineering Quality .
NCR N	lo				Use-as-is Work Order Update	Thern	noforming Large Fab	Finishing Composite	Rec/Stoi	re/Packaging Supplier	Other
Root				Descri	ption of work order update	Initial	Ac	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data											
Equip/Tooling											
Operator [		1				i				!	
Material		ł									
Setup											,
Other [										ļ	
Process					•						
Supplier			1							1	

Landin	g Gear	General	_			
	Bending	Bend	Grain	Ovalized		Pressure/Forced
	Centre Not Concentric to O/S	BOM/Route	Hardware	Over/Under tolerance		Temperature/Cure
	Cracks	Broken/Damaged	Inspection Incomplete	Part Incorrect		Weld
	Crushed/Crimped.	Burrs	Instructions Incomplete/Unclear	Part Lost/Missing		Wrong Stock Pulled
	Cuffs	Contamination	Maintenance	Part Moved		
	Heat Treat	Countersink	Mislabeled	Positioned Wrong		
	Inspection Strip in Tube	Cut Too Short	Misread	Power Loss/Surge	L	Other
	Ripples in Bend	Drill Holes	 Offset			
	Torque Waves in Extrusion	Drawing	Out of Calibration			
	Turning Sequence	Finish	Out of Sequence			
Γ	Wave/Twist in Tube	Folio	Outside Dimensions			

**FAULT CATEGORY** 

Training Unapproved Thursday, February 21, 2013 10:23:43 AM

Work Order ID: 97645

\*97645\*

Parent Item:

D4030-041

\*D4030-041\*

Parent Item Name: Long Basket Assembly (350)

Start Date: 2/21/2013

Required Date: 2/28/2013

Start Qty: 1.00

\*\*

\*\*

\*\*

Required Qty: 1.00

D3953-17

Manufactured No 100

Each 31.0000 2 2

Gas Spring Spacer

Location	Loc Oty	Loc Code
ST076	31	
88281	3	
89180	16	
94578	12	

D3953-19

D3953-21

D3969-3

Manufactured No

Manufactured

Manufactured

100 Each

14.0000

Gas Spring Bracket

ST077

No

No

Location

Loc Qty 14 14 100 Each Loc Code

16.0000

14.0000

Gas Spring Bracket

Location Loc Qty Loc Code ST077 16 85759 4

94146

92819

12 100 Each

\*\*

Spring (Basket Lid)

Location Loc Qty Loc Code ST262 14

91844

14

											DQA:	Date	e:
NCR:	Yes	/ No				WORK ORDER NON-C	ON	NFORN	AANCE / UPDA		QA Closed:	Date	e:
Work Orde	or.					DISPOSITION				AGAINST DEI	PARTMENT	PROCESS	
Part N	- No					Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube  Machining noforming  Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order update	Ī	nitial	Actio	n	Sign &		
Cause		Date	Step	Qty	(	or Non-conformance	Ch	ief Eng	Descrip	otion	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved													
						F/	AUL	T CATE	GORY				
Landi		Bending Centre No Cracks Crushed/I Cuffs Heat Trea Inspection	Crimped it n Strip in		O/S	General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short		Instruct Mainte Mislabe Misread	on Incomplete ions Incomplete/Ur nance led		Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ct sissing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
	ll	Ripples in	Bend			Drill Holes	1	Offset					

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

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Picklist Print Thursday, February 21, 2013 10:	·23:43 AM							Page 5
Work Order ID: 97645  Parent Item: D4030-041  Parent Item Name: Long Basket	Assembly (350)		7645* 4030-041*			Start Date: Start Qty:		Required Date: 2/28/2013 Required Qty: 1.00
AN3-14A	Purchased	No		100	Each	157.0000 4	4	
*AN3-14A*						**		
			<b>Location</b>	Loc	<u>Oty</u>	Loc Code		
			ST352		57		640 0-0	`
			122800		57		120 SV	,
			ST512 123759		100 100			
AN3-16A	Purchased	No	123739	100	Each	148.0000 2	2	
*AN3-16A*	Purchased	NO		100	Lach	**		
			Location	Loc	<u>Qty</u>	Loc Code		
			GA		47			
			117441		47			
			ST352		101		10	<u> </u>
			122407		51		12240	/
AN5-17A	Domeleses	No	123900	100	50 Each	151.0000 4	4	
	Purchased	INO		100	Lacii	**	4 -	1 12/2/201
*AN5-17A*						^^		(13/3/12)
			Location	Loc	<u>Otv</u>	Loc Code		
			GA		36			
			117872		36			
			ST337		115		$\overline{D}$	
			122416 123831		5 60		100416	?
			124215		50			-

											DQA:	Date:	
NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORM	MANCE / UP		QA Closed:	Date:	
						<u> </u>	_		··		QA Closed.	Date.	
Work Orde	er.					DISPOSITION				AGAINST DEI	PARTMENT	/PROCESS	
, work ora			······································	<del></del>		Rework	1		Skid-tube	Crosstube		Water Jet	Engineering
Part I	No.					Scrap	1	ı	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
	_					Use-as-is	]	Therm	noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR I	No					Work Order Update	]		Large Fab	Composite		Supplier	
			,										
Root			ĺ			ption of work order update	1	nitial		tion	Sign &		
Cause	$\Box$	Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data	Ц												
Equip/Tooling	Ц											* .	
Operator	Ц												,
Material	Ц												
Setup	Ш												
Other	Щ												
Process	Ш								<u> </u>				
Supplier	Щ												
Training	Н												
Unapproved			<u> </u>	<u> </u>	<u> </u>			TCATE	CORY	<del> </del>	l		<u> </u>
<u> </u>							AUI	T CATE	GUKY				
Landi		<b>ear</b> Bending			Γ	General Bend		Grain			Ovalized	Γ	Pressure/Forced
1	1 1	Bending			- 1	IRend	1	IGrain		i	lOvalized	ŀ	iPressure/Forced

ı	centre not concentric to 0/3	BOW/Route	naruware	Over/officer tolerance
	Cracks	Broken/Damaged	Inspection Incomplete	Part Incorrect Weld
	Crushed/Crimped.	Burrs	Instructions Incomplete/Unclear	Part Lost/Missing Wrong Stock Pulled
	Cuffs	Contamination	Maintenance	Part Moved
	Heat Treat	Countersink	Mislabeled	Positioned Wrong
	Inspection Strip in Tube	Cut Too Short	Misread	Power Loss/Surge Other
	Ripples in Bend	Drill Holes	Offset	
	Torque Waves in Extrusion	Drawing	Out of Calibration	
	Turning Sequence	Finish	Out of Sequence	
	Wave/Twist in Tube	Folio	Outside Dimensions	

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Thursday, February 21, 2013 10:23:43 AM

Work Order ID: 97645

\*97645\*

Parent Item:

D4030-041

\*D4030-041\*

Parent Item Name: Long Basket Assembly (350)

**Start Date: 2/21/2013** 

Required Date: 2/28/2013

Start Qty: 1.00

Required Qty: 1.00

AN4-12

Purchased

No

No

100 51.0000 Each

\*\*

\*\*

\*AN4-12\*

Location ST356

122800

123900

124221

Loc Qty 51

Loc Oty

Each

Loc Code

Purchased No

Purchased

51 100 Each

120.0000

\*AN310-4\*

AN310-4

Location ST342 122800

120 18 100

100

Loc Code

113900

\*\*

118.0000

\*AN310C4\*

AN310C4

Location Loc Oty Loc Code ST342 118 123831 18 124221 100

			DQA:	Date:
NCR:	Yes / N	WORK ORDER NON-CONFORMANCE / UPDATE		

											QA Closed:	Dat	e:
Work Orde	or.					DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
Part N	- No					Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube  Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	1	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order update	1	nitial	Act	tion	Sign &		
Cause		Date	Step	Qty	(	or Non-conformance	Ch	ief Eng	Desci	ription	Date	Verification	QC inspector
Doc/Data													
Equip/Tooling													
Operator							}						
Material													
Setup													
Other													
Process													
Supplier	Ш												
Training	Ц												
Unapproved			İ										
						····	AUL	T CATE	GORY				
Landi						General				_	<b>1</b>	Г	
	$\vdash$	Bending			.	Bend	-	Grain		-	Ovalized		Pressure/Forced
		Centre No	ot Concer	ntric to	o/s  _	BOM/Route	$\vdash$	Hardwa		-	Over/Under		Temperature/Cure
	$\vdash$	Cracks				Broken/Damaged	$\vdash$		ion Incomplete		Part Incorre	}	Weld
	-	Crushed/	Crimped.		-	Burrs	-		ions Incomplete/	Unclear	Part Lost/Mi	issing [	Wrong Stock Pulled
	-	Cuffs			-	Contamination	$\vdash$	Mainte		<u> </u>	Part Moved	<b>A</b> /	
		Heat Trea			-	Countersink	-	Mislabe		<u> </u>	Positioned V	- 1	241
	-	Inspection	-	Tube	$\vdash$	Cut Too Short		Misread	נ		Power Loss/	Surge	Other
	-	Ripples in			<u> </u>	Drill Holes	-	Offset	Calibaration				
	$\vdash$	Torque W			n	Drawing	$\vdash$		Calibration				
		Turning S			_	Finish	<u> </u>	1	Sequence				
1		Wave/Tw	rist in Tub	oe -		Folio	ı	Outside	Dimensions				

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Picklist Print Thursday, February 21, 2013 10:2	3:43 AM					<del></del>			Page '
Work Order ID: 97645  Parent Item: D4030-041  Parent Item Name: Long Basket As	ssembly (350)		7645* 94030-041*				Date: 2	/21/2013	Required Date: 2/28/2013 Required Qty: 1.00
MS21042L3 *MS21042I 3* Nut	Purchased	No		100	Each	7,055.000	6 <b>★</b>	6 🔎	
Trut			<b>Location</b>	<u>L</u>	oc Qty	Loc Code			
			FP001		3				_
			122141		3				_
			GA		354				_
			122452		354				_
			ST314		268				=
			117885		32				-
			119017 119075		55 138			-	_
			123265		43			<del>- • • • • • • • • • • • • • • • • • • •</del>	_
			ST506		6430				<del>-</del> .
			123900		2430			123700	
			124291		4000				- /
MS21042L5	Purchased	No		100	Each	1,049.000	4	4	
*MS21042L5*						*	*		
			Location	<u>L</u>	oc Qty	Loc Code			
			ST314		349				_
			108827		4				_
			116548		43				_

ST506

											DQA:	Date:	
NCR:	Yes /	No				WORK ORDER NON-C	100	VFOR	MANCE / UP		•		
											QA Closed:	Date:	
Work Orde	or:					DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
Part I		•	·	, <b>-</b> -		Rework Scrap		l.	Skid-tube Machining	Crosstube Small Fab	Pro	Water Jet	Engineering Quality
NCR I						Use-as-is Work Order Update		Thern	noforming Large Fab	Finishing Composite		e/Packaging Supplier	Other
Root					Descri	ption of work order update	1	nitial	Act	ion	Sign &		
Cause	[	Date	Step	Qty		or Non-conformance	Ch	ief Eng	Descr	ription	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling	Ш						1		-				
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						F	AUI	T CATE	GORY				<u> </u>
Landi	ng Gea	7				General				<u></u>		_	=
	Be	nding				Bend	L	Grain			Ovalized		Pressure/Forced
	Centre Not Concentric to O/S					BOM/Route	L	Hardwa	ire		Over/Under	tolerance	Temperature/Cure
	Cra	icks				Broken/Damaged		Inspect	ion Incomplete		Part Incorre	ct	Weld
	∐Crı	ushed/C	rimped.			Burrs		Instruct	ions Incomplete/l	Jnclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cu	ffs				Contamination		Mainte	enance		Part Moved		
	He	at Trea	t			Countersink		Mislabe	eled		Positioned V	Vrong	

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish

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<b>Picklist Print</b> Thursday, February 21, 2013  10:23:43	3 AM									Page
Work Order ID: 97645  Parent Item: D4030-041  Parent Item Name: Long Basket Assem	bly (350)		7645* 4030-			· · · · · · · · · · · · · · · · ·		art Date:	2/21/2013 1.00	Required Date: 2/28/2013 Required Qty: 1.00
*M\$24665-151 *M\$24665-151*	Purchased	No			100	Each	143.0000	3 <b>**</b>	3,	
Cotter Pin			ST323	7566 22802	L	38 38 105 105	Loc Code		122502	
*M\$24665-300 *M\$24665-300* Cotter Pin	Purchased	No		2002	100	Each	239.0000	2 **	2 -	
			ST299	18234 24555	<u>L</u>	39 39 200 200	Loc Code		124868	
NAS1149F0432P *NAS1149F0432F Washer	Purchased	No			100	Each	958.0000	6 <b>**</b>		<u> </u>
			1: 1:	22151 23522 23900 24580	<u>L</u>	958 2 4 552 400	Loc Code		/23500	
NAS1149F0563P *NAS1149F0563F Washer	Purchased	No			100	Each	774.0000	4 **	4	D13/3/13
			Location ST295	21350	L	oc Oty 774 774	Loc Code		12/35	

											DQA	: Date	e: _	
NCR:	Yes	/ No				WORK ORDER NON-C		NFORM	MANCE / UP	DATE				
						<i>p</i>					QA Closed	: Date	e:	
Work Orde	er.					DISPOSITION				AGAINST DE	PARTMEN	r/PROCESS		
Part No.						<b>1</b>		Therm	Skid-tube Crosstube Machining Small Fab Thermoforming Finishing		Water Je Prod. Eng. Coor Rec/Store/Packagin			Engineering Quality Other
NCR I	No					Work Order Update	]		Large Fab	Composite	j	Supplier		
Root					Descri	tion of work order update		nitial	Ac	tion	Sign &		T	· · · · · · · · · · · · · · · · · · ·
Cause		Date	Step	Qty	(	or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	١	QC Inspector
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Landi	ng G	ear				General		_			_			
		Bending				Bend		Grain			Ovalized	[	I	Pressure/Forced
	Centre Not Concentric to O/S					BOM/Route		Hardwa	re		Over/Unde	r tolerance	<u> </u>	Temperature/Cure
	Cracks					Broken/Damaged	Г	Inspecti	on Incomplete		Part Incorr	ect	$\Box$	Weld
		Crushed/0	Crimped.			Burrs	Г	Instruct	ions Incomplete/	Unclear	Part Lost/Missing			Wrong Stock Pulled
	$\boldsymbol{-}$	Cuffs				Contamination		Mainte	nance		Part Move	d		
	П	Heat Trea	t			Countersink		Mislabe	led		Positioned	Wrong		
	Inspection Strip in Tube					Cut Too Short	Misread				Power Loss	S/Surge		Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

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Thursday, February 21, 2013 10:23:44 AM

Work Order ID: 97645

Parent Item:

D4030-041

Parent Item Name: Long Basket Assembly (350)

\*97645\*

\*D4030-041\*

**Start Date: 2/21/2013** 

Required Date: 2/28/2013

Page 9

Start Qty: 1.00

Required Qty: 1.00

NAS1149F0332P

Purchased

No

123900

Each

100

100

10,560.00

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\*NAS1149F0332P\*

WASHER

Location Loc Oty Loc Code GA 194 122063 194 ST294 363 122063 122063 363 ST295 3 123352 3 10000 st510

NAS1149C0432R

Purchased

No

2,818.000

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\*NAS1149C0432R\*

<b>Location</b>	Loc Qty	Loc Code	
GA	33		
121255	33		
ST292	2785		
119124	6		
122441	2779		1.

10000

Each

												DQA:	Da	ate: _	
NCR:	res /	No				WORK ORDER NON-C	O	NFORM	AANCE / UP	DATE					
												QA Closed:	Da	ate:	
Work Orde	<b></b>					DISPOSITION				AGAINST	DE	PARTMENT	PROCESS		
WORK OTHE	=·				<del></del>	Rework	1		Skid-tube	Crosstube		]	Water Jet	t 🗀	Engineering
Part N	No.					Scrap	1 1		Machining	Small Fab		Pro	d. Eng. Coor	$\vdash$	Quality
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NCR I	No.					Work Order Update	1 1		Large Fab	Composite			Supplie		
Root					l .	ption of work order update		nitial	Ac	tion		Sign &			
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desc	ription		Date	Verification	on	QC Inspector
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Equip/Tooling															
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Material															
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Training															
Unapproved							<u>l</u>					l	<u></u>		
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Landi	ng Gea				_	General	_	7				٦		_	1 .
	⊢—	nding			_	Bend	_	Grain			_	Ovalized		$\vdash$	Pressure/Forced
	<del></del>		t Concer	ntric to	o/s	BOM/Route	<u></u>	Hardwa			_	Over/Under		$\vdash$	Temperature/Cure
	<del></del>	acks			ļ	Broken/Damaged	$\vdash$	4	on Incomplete		_	Part Incorre		<u> </u>	Weld
	Cri	ushed/0	Crimped.		L	Burrs	<u></u>	1	ions Incomplete/	'Unclear	_	Part Lost/M	_	L	Wrong Stock Pulled
1	Cuffs					Contamination	ı	Mainte	nance		i	Part Moved			

Mislabeled

Out of Calibration
Out of Sequence

Outside Dimensions

Misread

Offset

Positioned Wrong

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

Countersink

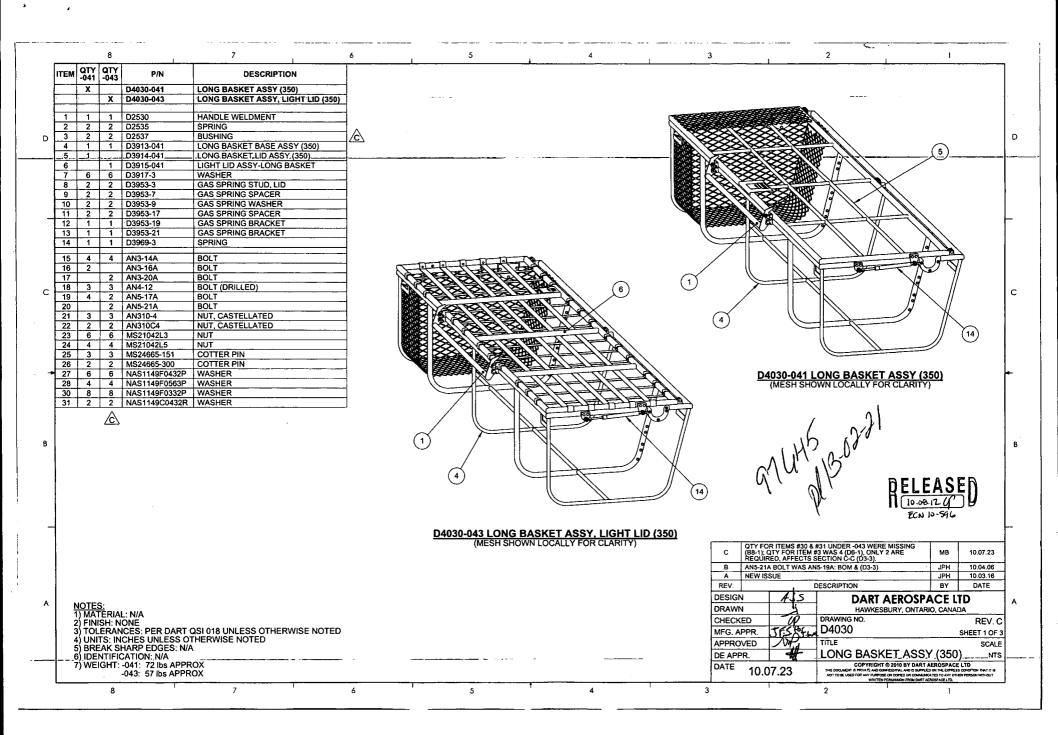
Cut Too Short

Drill Holes

Drawing

Finish

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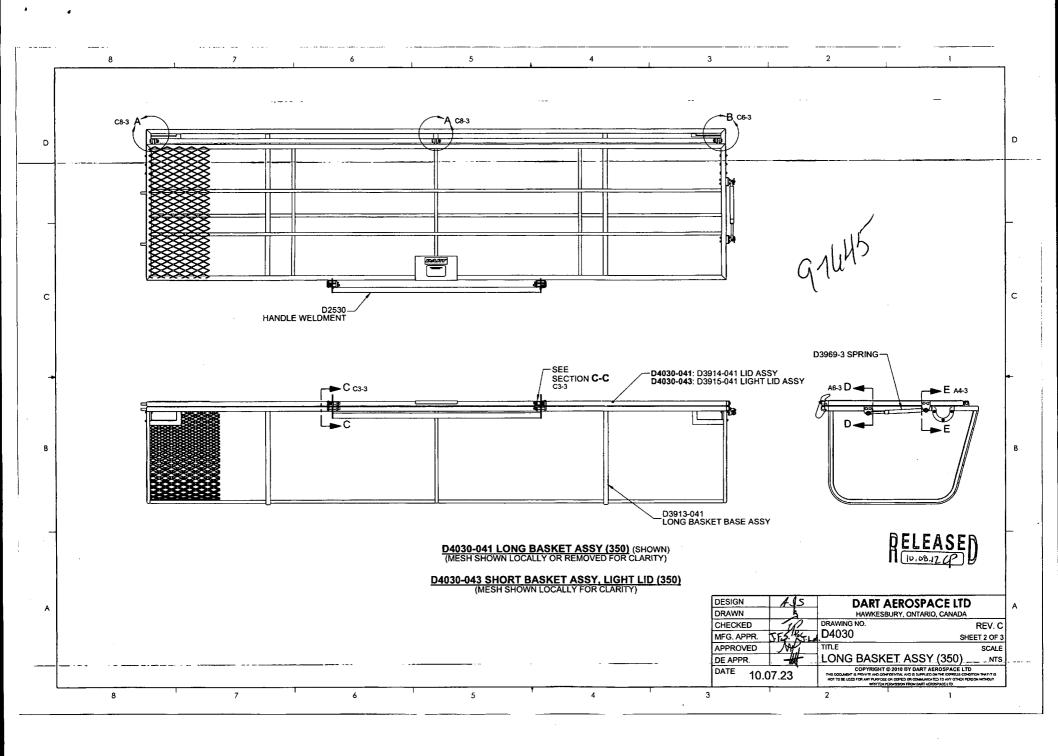
							DQA:	Date:				
es / No			WORK ORDER NON-	WORK ORDER NON-CONFORMANCE / UPDATE								
er:			DISPOSITION		AGAINST DEPARTMENT/PROCESS							
No			Rework Scrap Use-as-is Work Order Update	-} <b>1</b>	Skid-tube Crosstube  Machining Small Fab  Thermoforming Finishing  Large Fab Composite			· · · —	Engineering Quality Other			
	T T		Description of work order update	Initial	Act	ion	Sign &					
Date	Step	Qty	or Non-conformance	Chief Eng	Descr	ription	Date	Verification	QC Inspector			
				Ī								
						•		•				
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	er: No	er: No	No	DISPOSITION  Rework  Scrap  Use-as-is  Work Order Update  Description of work order update	DISPOSITION  Rework  Scrap  Use-as-is  Work Order Update  Description of work order update Initial	Per:    DISPOSITION   Rework   Skid-tube   Machining   Thermoforming   Large Fab     Description of work order update   Initial   Act	Per:    DISPOSITION	WORK ORDER NON-CONFORMANCE / UPDATE  QA Closed:  DISPOSITION  Rework Scrap Use-as-is Work Order Update  Description of work order update  No.  Description of work order update  Description of work order update  QA Closed:  AGAINST DEPARTMENT, Skid-tube Machining Machining Thermoforming Large Fab Composite  Sign &	WORK ORDER NON-CONFORMANCE / UPDATE  QA Closed: Date:  DISPOSITION  Rework Skid-tube Crosstube Water Jet Machining Small Fab Prod. Eng. Coor. Use-as-is Work Order Update Large Fab Composite Supplier  Description of work order update Initial Action Sign &			

## **Landing Gear** General Bend Grain Ovalized Pressure/Forced Bending BOM/Route Centre Not Concentric to O/S Over/Under tolerance Temperature/Cure Hardware Weld Cracks Broken/Damaged Inspection Incomplete Part Incorrect Wrong Stock Pulled Crushed/Crimped Instructions Incomplete/Unclear Part Lost/Missing Burrs Contamination Maintenance Part Moved Cuffs Heat Treat Countersink Mislabeled Positioned Wrong Other Inspection Strip in Tube Misread Power Loss/Surge Cut Too Short Ripples in Bend Drill Holes Offset Torque Waves in Extrusion Drawing Out of Calibration Turning Sequence Finish Out of Sequence Folio Wave/Twist in Tube Outside Dimensions

**FAULT CATEGORY** 

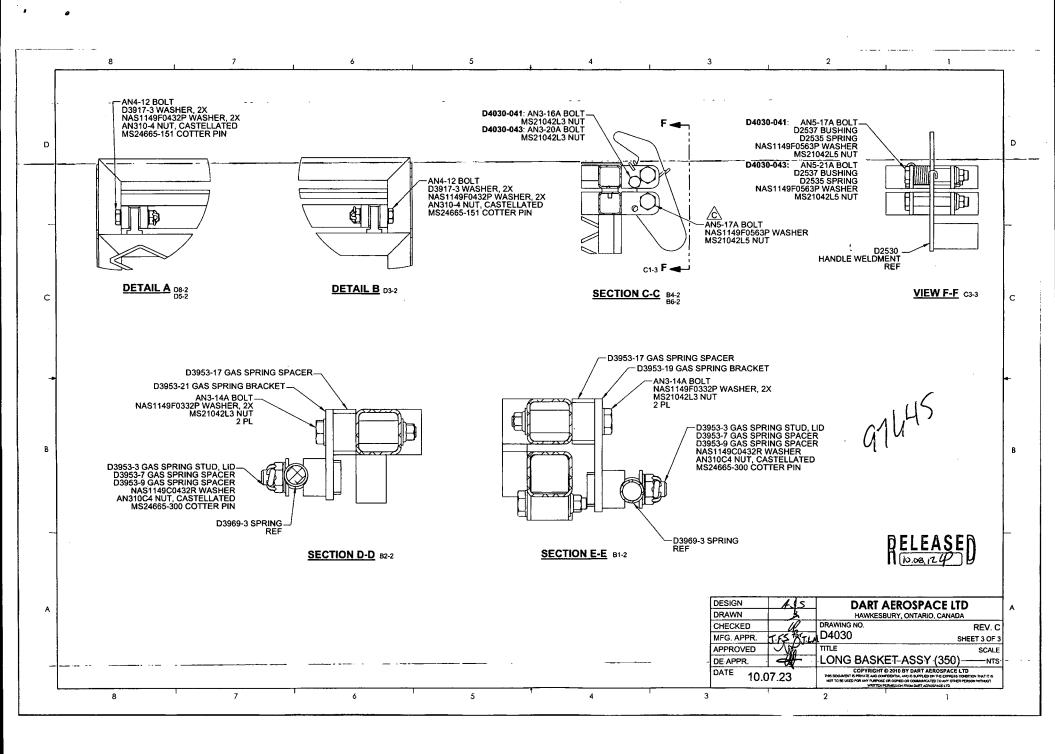
Other Process Supplier Training Unapproved

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					•					DQA:	Date	2:		
NCR: Y	es / No				WORK ORDER NON-	CONFO	RMA	ANCE / UPI	DATE	QA Closed:	Date			
					DISPOSITION				AGAINST D	EPARTMENT	****			
Work Orde	r:				DISPOSITION	_			Adalita		_			
Part N NCR N					Rework Skid-tube Scrap Machining Use-as-is Thermoforming Work Order Update Large Fab			chining orming	Crosstube Water Jet Engineering Small Fab Prod. Eng. Coor. Quality Finishing Rec/Store/Packaging Other Composite Supplier					
Root				Descri	ption of work order update	Initia		Act	tion	Sign &				
Cause	Date	Step	Qty		or Non-conformance	Chief E	i	Desci	ription	Date	Verification	QC Inspector		
Doc/Data														
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Landin	g Gear				General	7.027 07								
[	Bending			Г	Bend	Gra	in		Γ	Ovalized	Γ	Pressure/Forced		
Ī	Centre No	ot Conce	ntric to (	o/s	BOM/Route	Hard	dware		-	Over/Under	tolerance	Temperature/Cure		
Ī	Cracks	-1				Insp	ection	Incomplete		Part Incorre	ct [	Weld		
	Crushed/	Crimped			Burrs	Inst	ruction	s Incomplete/	Unclear	Part Lost/M	issing	Wrong Stock Pulled		
	Cuffs	<b>─</b>				Mai	intena	ince		Part Moved				
	Heat Treat Countersink					Misl	labeled	<del>j</del>		Positioned \	Vrong			
	Inspectio	n Strip in	Tube		Cut Too Short	$\vdash$	read		Ĺ	Power Loss	'Surge	Other		
Į	Ripples ir	n Bend			Drill Holes	Offs								
	Torque W			n	Drawing	<del></del>		bration						
ļ	Turning S	•		ļ	Finish	Out	of Seq	uence						
	Wave/Tw	vist in Tul	be		Folio .	Out	Outside Dimensions							

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						•				DQA:	Date:	
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Work Orde	r·					DISPOSITION			AGAINST DE	PARTMENT,	PROCESS	
Part N	o					Rework Scrap Use-as-is Work Order Update	₹ 1	Skid-tube  Machining  noforming  Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order update	Initial	Ad	ction	Sign &		
Cause	Dat	e	Step	Qty	(	or Non-conformance	Chief Eng	Desc	cription	Date	Verification	QC Inspector
Doc/Data												
quip/Tooling												
Operator		1										
Material [												
Setup						•						
Other												

## **FAULT CATEGORY Landing Gear** General Bend Grain Ovalized Pressure/Forced Bending BOM/Route Centre Not Concentric to O/S Over/Under tolerance Temperature/Cure Hardware Part Incorrect Weld Cracks Broken/Damaged Inspection Incomplete Wrong Stock Pulled Crushed/Crimped. Instructions Incomplete/Unclear Part Lost/Missing Burrs Maintenance Part Moved Cuffs Contamination Countersink Mislabeled Positioned Wrong **Heat Treat** Other Inspection Strip in Tube Misread Power Loss/Surge Cut Too Short Ripples in Bend Drill Holes Offset Torque Waves in Extrusion Drawing Out of Calibration Out of Sequence Turning Sequence Finish Wave/Twist in Tube Folio Outside Dimensions

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Supplier Training Unapproved